

## CLAIMS

1. A method for web folding and wetting comprising:  
dispensing said webs from roll unwind stands;  
feeding said webs at a continuous speed via S-Wrap drive rollers;  
passing said webs over stationary wetting tubes;  
dispensing wetting solution onto said web;  
passing said webs onto folding plates;  
folding said webs into “Z”, “C”, “W” or “e” fold configurations.
2. The method of claim 1 wherein said webs are used for cleaning and/or hygienic wiping.
3. The method of claim 1 further comprising:  
cutting said web into appropriate lengths.
4. The method of claim 1 wherein said method folds and wets eight continuously moving webs.
5. The method of claim 3 further comprising:  
dispensing a web of packaging material;  
slitting score lines into said packaging material;  
wrapping said folded webs.
6. The method of claim 1 wherein said web speed ranges from about 180” per minute to 900” per minute.
7. The method of claim 1 wherein flow rate of said wetting solution is automatically adjusted by a control system to compensate for changing web speeds.
8. The method of claim 7 wherein said control system monitors and controls flow rates of solution dispensed.

9. The method of claim 1 wherein said web is weighed on line after wetting solution is dispensed on said web to see if correct amount of fluid has been added to said web.

10. A system for folding and wetting webs comprising:

roll unwind stands,

S-Wrap drive rollers,

stationary wetting tubes,

guide rollers; and

folding plates.

11. The system of claim 10 wherein said system is portable with clamp locking casters.

12. The system of claim 10 wherein said system comprises eight quick change folding plate assemblies.

13. The system of claim 10 further comprising:  
a razor-slitter/anvil roll assembly.

14. The system of claim 10 further comprising:  
a surge tank for holding solution pumped from a storage tote, tank, or drum which allows for changeover of storage containers without interrupting operation of said system.

15. A Solution Dispensing System which automatically controls and meters dispensing of solutions comprising:

a number of port manifolds which can be set to dispense a given liquid volume;  
said solution dispensing system comprised of four distinct operating modes, an application mode, a surge tank drain mode, a surge tank flush CIP mode and a CIP pressure pump and applicator mode.

16. A transfer pump clean-in-place mode system comprising:

- an open loop operation that is repeated in three sequences with a Pressure Pump and valve clean-in-place operation;
- at termination of each of said three sequences, solution being used for the CIP operation may either be gravity drained from said system, or pumped to drain by use of a surge tank drain mode;
- after introduction of cleaning solution into said surge tank from an external source, said solution is drawn from the bottom of said surge tank by a tote transfer pump;
- said cleaning solution is pumped to the top of said surge tank;
- a spray-ball disperses said cleaning/rinsing solutions to all surfaces of the tank.